

ABSTRACT

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A method of coating a substrate comprises the steps of applying a coating composition to selected areas of the substrate. The coating composition comprises a mixture including at least a reactive part. The reactive part comprises between 30% and 100% multi-functional material, and is photoinitiator free. The coated substrate is exposed, in a curing zone, to ultra-violet light from at least one lamp which has a power output of at least 140 watts per linear centimeter. The ultra-violet light initiates curing of the coating. A substantially inert atmosphere is maintained in the curing zone where the substrate is exposed to the ultra-violet light.

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